

Date: Monday, 18/08/2008 3:40:08 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: EC 135 SKIDTUBE ASSEMBLY
Job Number	: 41332		
Estimate Number	: 12472		
P.O. Number	:	Part Number	: D135751011
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: D3507 UNDER REVIEW <i>At 08.10.31</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SKIDTUBES	Drawing Revision	: C
Previous Run	: 28957	Material	:
Written By	:	Due Date	: 20/09/2008 Qty: 1 Um: Each
Checked & Approved By	: <i>JLD 08.8.18</i>		
Comment	: Est Rev:A 06-06-21 New Issue JLM Est Rev:B 06-12-18 As per Rev B JLM Est Rev:C 07-12-11 ECN 1036 as per revB DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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*JLD 08.09.11*

Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D135-751-011 CHG001

*5 08/03/08*

2.0	D2962150	3.540 Outer Tube, Extrud
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion *28672**RT 08-08-26*

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

*RT 08-08-26*

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

*RT 08 08 28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

08-08-28

2-Cut Aft end at VC using DT8185

3-Deburr ends

4-Drill Aft & Fwd Cap holes using DT8678

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with 3/16" cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using 3/16" drill. \*\*\*DO NOT OPEN AFT CAP HOLES\*\*\*\*\*

7-Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Deburr holes.

P10

RT  
08-09-08

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

66/10/09 (20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11 8-10-14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION




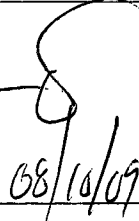
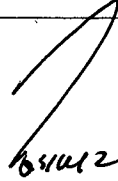

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D135-751-011 PAR #: N/A Fault Category: Prod/Skidube NCR: (Yes) No DQA: D Date: 08/10/09  
 QA: N/C Closed: H Date: 08/11/04

NCR: 41332		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-10-09	5.0	Employee drilled the holes off of the wear plate sig DT8868. Holes are to be drilled off of DT8892. R.C. Under Review & design changes.		- Fill the 6 AFT wear plate holes with weld and grind flush. A/R M/09213 - Re-drill holes with DT8892 per dwg.	BE 09 08-10-09 RT 08-10-09			
		Lack of Attention						

NOTE: Date & initial all entries

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 41332

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D35043

375

Crossbolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSBOLT SPACER

Batch:

B 31232

BE 08/10/21

10.0

D35041

5

Crossbolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CROSSBOLT SPACER

Batch:

B 31234

BE 08/10/21

11.0

D35051

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

Batch:

42531

42 08-10-16

12.0

D35061

Doubler



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

DOUBLER

Batch:

B 41605

JB 8-10-22

13.0

D35063

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

DOUBLER

Batch:

B 28964

JB 8-10-22

14.0

D35045

750

Crossbolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CROSSBOLT SPACER

batch:

B 36181

BE 08/10/21

15.0

MS20601AD4W3

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rivet

Batch:

B 107823

JB 8-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: 109378

Exp Date: 8-11-05

5-Weld x-bolt (D3504-1/-3)spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: m109213

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

RT 08-10-15

RT 08-10-16

JB 8-10-22

Tools: E

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5 08/10/22 @

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet D3506-1/-3 as per Dwg D3507.

JB 8-10-22

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/22 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 41332

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(14)

Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

*M-L*

08/10/25

21.0

POWDER COATING

POWDER COATING



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00  
320 °F  
1:30

*M-L*

08/10/25

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-27

(X1)

23.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: M105819

*ML*

\*

24.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: M100621

*ML*

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3507.

*ML*

08-10-27

(X1)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

08/10/27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 41332

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: M108062

JS

28.0

D29653

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B29993

JS

29.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B341523

JS

30.0

D35081

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B31195

JS

31.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B38527

JS

32.0

D35085

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B31197

JS

33.0

D35087

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B36198

JS

08.10.27

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Monday, 18/08/2008 3:40:09 PM  
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Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 41332

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D35581

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 29998

*JH*

35.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 338613

*JH*

36.0

D35585

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 3000

*JH*

37.0

D35587

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 336388

*JH*

38.0

D3492041

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

Batch: B 334182

*JH*

39.0

D3492043

Plug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY

batch B 341138

*JH*

40.0

D3492047

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

Batch: B 328961

*JH*

08.10.27

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 41332

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total: 33.0000 Each(s)

Washer

Batch: M109282

94

42.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total: 31.0000 Each(s)

BOLT

Batch: (20x) M109297 (11x) M109431

94

43.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M1108928

94

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign objects

✓ 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M109449  
Exp Date: 08/11

✓ 3-Install Wearplates as per Dwg D3507 ,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Scews where indicated on Dwg(Note #6)

✓ A/R 241 Sika Flex Batch: M1109449  
Exp Date: 08/11

✓ 4-Install Plug assemblys as per Dwg D3507.

5- Wing Walk as per Dwg D3043 and QSI 005 4.4

A3507

- M109219

FZ 08/10/27

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 08/0/28 @

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0

D35121

Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WEARPLATE

Batch:

33115 40360

SS 08/0/29

48.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch:

M105793

SS 08/0/29 @

49.0

AN3C4A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

BATCH:

M108599

Batch not in comp

SS 08/0/29 @

50.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/0/30 @

51.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-751-011

Location:

PPP Rev:

Rev B

SS 08/0/29 @

B 41332

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Machine Or Operation:

Description :

52.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/31 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mf* 08-10-30

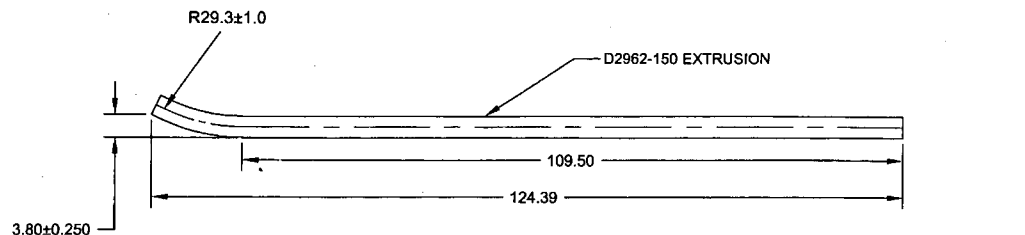
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

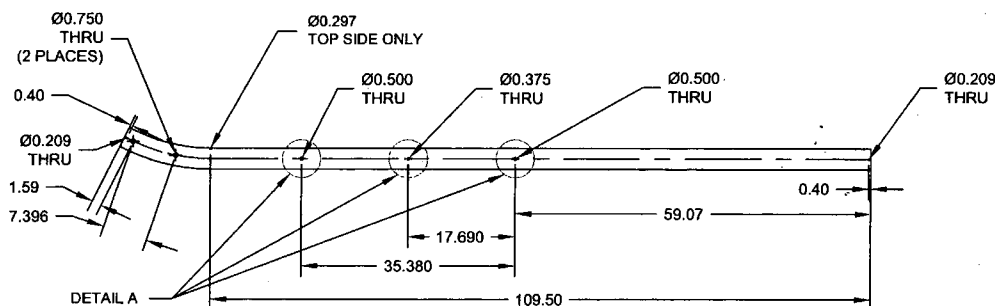
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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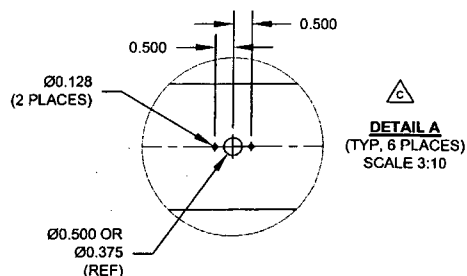
NOTE: Date & initial all entries



**D3507-1 BENDING/CUTTING DETAIL**



**D3507-1 DRILLING DETAIL**



Qty	Part Number	Description
X	D3607-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

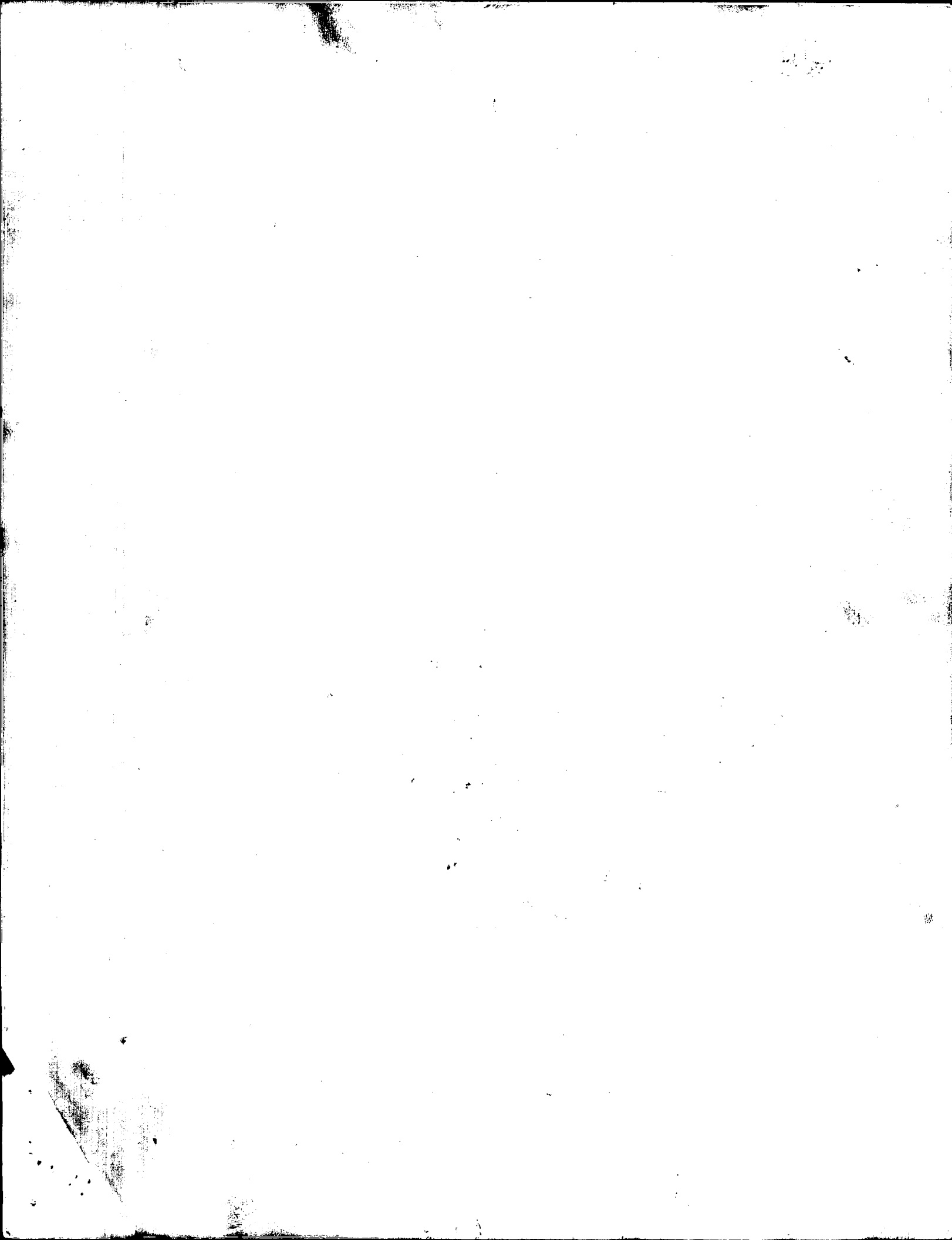
**GENERAL NOTES:**

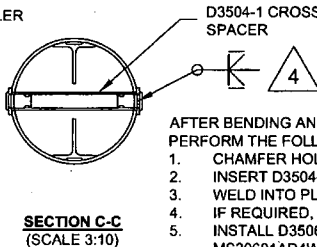
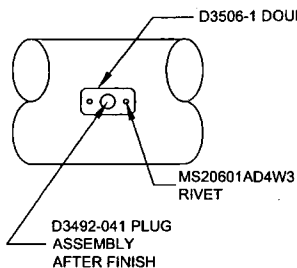
- 1) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4.
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JIC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.09.19		

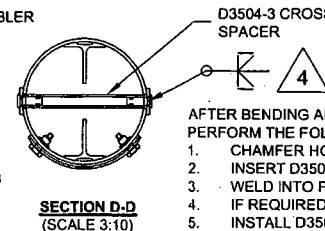
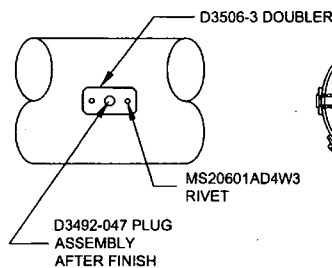
DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. C
D3507	SHEET 1 OF 2
TITLE	SCALE
EC 135 SKIDTUBE	NTS
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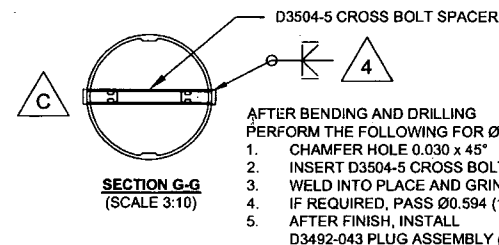
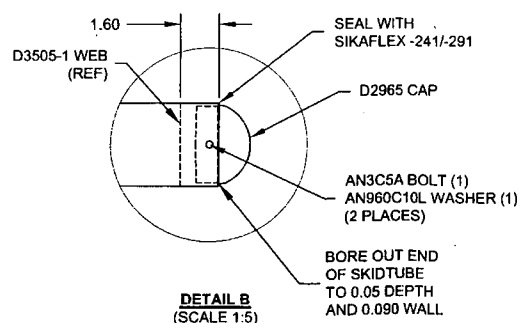
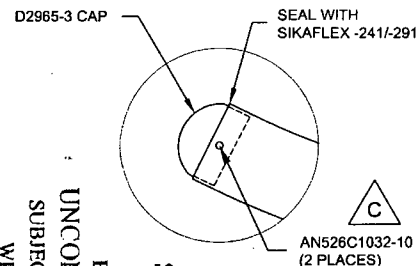
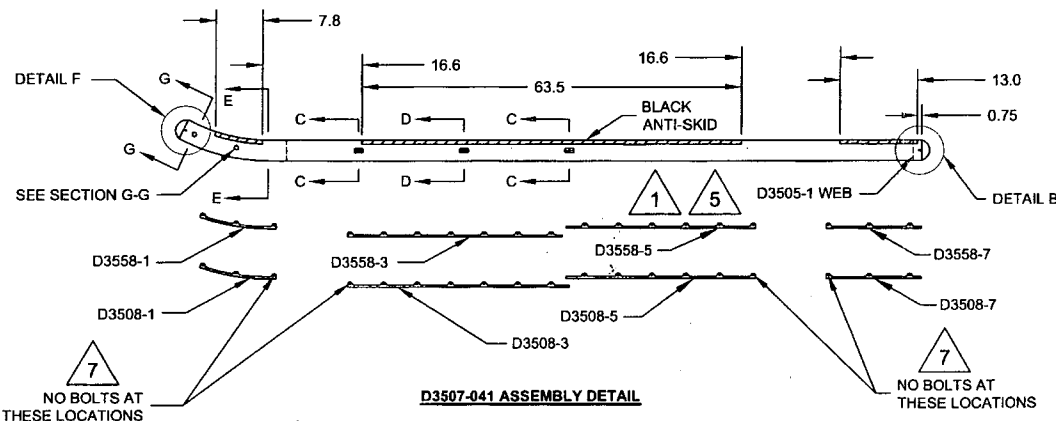




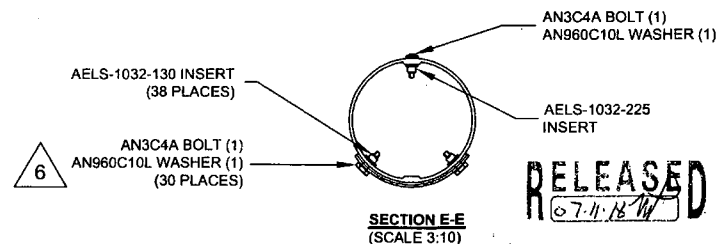
- AFTER BENDING AND DRILLING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-1 CROSS BOLT SPACER (2 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.404 (7/16" DRILL) THRU HOLE
  5. INSTALL D3506-1 DOUBLER (4 PLACES) USING MS20601AD4W3 RIVET (8 PLACES)
  6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY (4 PLACES)



- AFTER BENDING AND DRILLING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-3 CROSS BOLT SPACER (1 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.277 (J' DRILL) THRU HOLE
  5. INSTALL D3506-3 DOUBLER (2 PLACES) USING MS20601AD4W3 RIVET (4 PLACES)
  6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY (2 PLACES)



- AFTER BENDING AND DRILLING  
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-5 CROSS BOLT SPACER (2 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
  5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY (4 PLACES)



RELEASED  
07-11-18

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CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D3507	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	EC 135 SKIDTUBE	1:20
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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NO. 179

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 841333  
Part number: 135 751011  
Description: SKID tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum.  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[ ] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[ ] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Lund Date of Test Coupon 08/10/22

Welder Barclay Elliot Date of Test Coupon 08/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld